

Work Order ID 78382

78382

Page 1

Friday, January 06, 2012 3:04:17 PM

Item ID: D350-794-041

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Tank Assembly

Stop ***NS2***

Start Date: 1/9/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 2/10/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: *ymf*

Date: *1-01-06*

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

IIN-D350-794

C

100

100

DC

Document Control

DOCUMENT CONTROL

Memo

Photocopy bluefile & type labels per PPPD350-794-041

0.00

0.00

CHG003

8/2/06

Per MJS 12-2-6

110

110

Packaging

Packaging

Pick Kit

Memo

0.00

0.00

SP 12-02-07

120

120

QC

Quality Control

QC4- 100% Inspect kits for completeness

Memo

0.00

0.00

8/2/06

(7)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 78382***78382***

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Item ID: D350-794-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Tank Assembly

Start Date: 1/9/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 2/10/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Packaging	0.00							
130									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPPD350-794-041								
	Location: _____								
	PPP Rev: <u>PPP 78383</u>								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

*12/2/16**12/2/16**ME 12-02-16*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Picklist Print

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Work Order ID: 78382

Parent Item: D350-794-041

Parent Item Name: Tank Assembly

Start Date: 1/9/2012

Required Date: 2/10/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 10.05.17 ECN10-562 DD verf: IPP Rev B 10.11.18 updated pick
list EC verified by: DD - IPP REV:C 11.09.27 AS PER CHG 003 DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN816-6D Nipple-M-6Flare -1/4NPT		Purchased	No			110	Each	13.0000	1	1			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST325		13							
				118378		3							
				118529		10							
D4008-041 Fuel Filler Splash Guard Assembly		Manufactured	No			110	Each	6.0000	1	1			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST108		6							
				72792		6							
D4025-1 Fuel Quantity Sender		Manufactured	No			110	Each	5.0000	1	1			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST141a		5							
				71765		4							
				72257		1							
D4055-041 Fuel Tank Assembly		Manufactured	No			110	Each	0.0000	1	1			
D4023-1 Cap and Flange		Manufactured	No			110	Each	7.0000	1	1			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST110		7							
				64879		6							
				66862		1							
D4002-041 Aux Tank Drain Hose Assembly, Fwd		Manufactured	No			110	Each	2.0000	1	1			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST193		2							
				73558		2							

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

Picklist Print

Friday, January 06, 2012 3:04:16 PM

Page 2

Work Order ID: 78382
Parent Item: D350-794-041
Parent Item Name: Tank Assembly

Start Date: 1/9/2012 Required Date: 2/10/2012
Start Qty: 1.00 Required Qty: 1.00

D4002-043 Manufactured No 110 Each 2.0000
Aux Tank Drain Hose Assembly, Aft

1 B79315 SP

Location Loc Qty Loc Code

ST193 2
73554 2

MS20822-3D Purchased No 110 Each 13.0000
Elbow

2 SP 2

Location Loc Qty Loc Code

ST299 13
118529 3
119109 5
120142 5

MS20822-8D Purchased No 110 Each 10.0000
Elbow-90M-1/2Flare-3/8NP

2x
1 SP 1

Location Loc Qty Loc Code

ST299 10
118529 9
16762 1

D4009-041 Manufactured No 110 Each 1.0000
Bonding Braid

1x
2 B78959² B 79930²

Location Loc Qty Loc Code

ST108 1
72443 1

TBA28B D3600-1 Purchased No 110 Each 0.0000
Cable Tie Fastener

3 - B 66957 3x

TY25MX Purchased No 110 Each 892.0000
Tie Wrap

1 SP 12-02-07

Location Loc Qty Loc Code

ST380 892
115695 892

1x

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

4.0 ELECTRICAL LOAD

The electrical load effect for each aircraft must be assessed as follows.

Component	Load
Fuel Pump	3.00 Amps
Fuel Gauge	0.45 Amps
Fuel Sender	0.13 Amps
Total Installation	3.58 Amps = 100 Watts

5.0 WEIGHT AND BALANCE

The following is the weight increase associated with the Aux Fuel Tank Installation. Be sure to subtract the weight of any parts or material removed.

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D350-794-011 Auxiliary Fuel Tank (AS350 models)	29.8 lb 13.5 kg	-22.0 in -0.56 m	-655.6 in-lb -7.56 m-kG	126.0 in 3.20 m	3754.8 in-lb 43.2 m-kG
D350-794-013 Auxiliary Fuel Tank Provisions (AS350 models)	5.5 lb 2.5 kg	-14.6 in -0.37 m	-80.3 in-lb -0.93 m-kG	163.4 in 4.15 m	898.7 in-lb 10.4 m-kG
D130-794-021 Auxiliary Fuel Tank (EC130 models)	29.8 lb 13.5 kg	-23.6 in -0.60 m	-703.3 in-lb -8.1 m-kG	126.0 in 3.20 m	3754.8 in-lb 43.2 m-kG
D130-794-023 Auxiliary Fuel Tank Provisions (EC130 models)	5.5 lb 2.5 kg	-16.1 in -0.41 m	-88.6 in-lb -1.03 m-kG	163.4 in 4.15 m	898.7 in-lb 10.4 m-kG

6.0 PARTS LIST

Qty -011	Qty -013	Qty -021	Qty -023	Qty -041	Part Number	Superseded Part Numbers	Description
X					D350-794-011		AUXILIARY FUEL TANK (AS 350 SERIES)
1	X				D350-794-013		AUXILIARY FUEL TANK PROVISIONS (AS 350 SERIES)
		X			D130-794-021		AUXILIARY FUEL TANK (EC 130 SERIES)
		1	X		D130-794-023		AUXILIARY FUEL TANK PROVISIONS (EC 130 SERIES)
1		1		X	D350-794-041		TANK ASSEMBLY
				1	D4055-041	JCA/M47-1-01A	FUEL TANK
	1		1		D4022-041	A8150-B1-JCA	FUEL TRANSFER PUMP ASSEMBLY
				1	D4023-1	ER281	FUEL CAP
	1		1		D4002-5	JCA-M47-2-13	SUPPLY HOSE - FROM AUX TANK
	1		1		D4003-047	JCA-M47-2-16	FUEL PUMP INLET PIPE
	1		1		D4002-7	JCA-M47-2-25	SUPPLY HOSE - PUMP TO MAIN TANK FILLER NECK
				1	D4002-041	JCA-M47-1-13	DRAIN HOSE ASSEMBLY - FRONT
				1	D4002-043	JCA-M47-1-16	DRAIN HOSE ASSEMBLY - REAR
				2	MS20822-3D		UNION
	1		1		AN832-6D		BULKHEAD UNION
				1	AN816-6D		STRAIGHT FITTING
	2		2		AN924-6D		NUT (ALTERNATE AS5178D06)
	2		2		NAS1149D0963J		WASHER

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Revision: C

Date: 10.01.25

REFERENCE ONLY

DART AEROSPACE LTD.

IIN-D350-794

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Qty -011	Qty -013	Qty -021	Qty -023	Qty -041	Part Number	Superseded Part Numbers	Description
				1	MS20822-8D		90° FITTING
	2		2		AN815-6D		UNION
	2		2		MS29512-06		ORING
	1		1		D4022-3	05-00021	FUEL PUMP MOUNTING BRACKET
	2		2		AN3-4A		BOLT
	2		2		MS21042-3		NUT
	2		2		AN970-3		WASHER
	1		1		D4008-043	JCA-M47-2-29	FUEL PUMP SPLASH GUARD
	1		1		D4004-7	N3	HOSE CLIP
				2	D4009-041	JCA-M47-4-01	BONDING BRAID
				1	D4008-041	JCA-M47-2-26	AUXILIARY TANK FILLER SPLASH GUARD
	4		4		AN525-10R6		SCREW
	1		1		D4001-3	AN832-6D-JCA	BULKHEAD FITTING - MODIFIED
	7		7		CR3212-5-5		CHERRY MAX RIVET
	18		18		CR3213-4-3		CHERRY MAX RIVET
	4		4		CR3212-4-3		CHERRY MAX RIVET
	12		12		MS20470AD4-6		RIVET
	32		32		MS20470AD3-4		RIVET
	16		16		MS20470AD5-6		RIVET
	6		6		MS20470AD5-8		RIVET
	9		9		CR3213-5-2		CHERRY MAX RIVET
	6		6		CR3212-5-4		CHERRY MAX RIVET
	3		3		CR3212-5-3		CHERRY MAX RIVET
	10		10		CR3212-5-2		CHERRY MAX RIVET
							Vent Assembly Parts
	2		2		MS21919WDG-8		CLAMP
	1		1		D4003-11	JCA-M47-2-21	VENT PIPE - TANK
			1		D4027-041	JCA-M47-2-20	VENT CLAMP ASSEMBLY
	1		1		D4003-049	JCA-M47-2-17	VENT PIPE - TANK
	1		1		D4027-043	JCA-M47-2-35	VENT CLAMP ASSEMBLY
	1		1		D4063-3	193-8	VENT HOSE
	2		2		2000-8S		HOSE CLAMP
	1		1		NAS43DD3-32N		SPACER
	1		1		MS35207-267		SCREW
	2		2		MS35207-264		SCREW
	3		3		NAS1149D0332J		WASHER
	3		3		MS21042-3		NUT
				3	TBA28B		CABLE TIE FASTENER
				1	TY25MX		TIE WRAP
	1		1		MS21919WDG-6		CLAMP (RUBBER REMOVED)
	1		1		D4009-041	JCA-M47-4-01	BONDING BRAID ASSEMBLY
							Restraint Assembly Parts
	1		1		D4005-1	JCA-M47-2-03	REAR RESTRAINT ANGLE/GUTTER
	1		1		D4004-11	JCA-M47-2-11	TOP STRAP ATTACH BRACKET
	1		1		D4004-5	JCA-M47-2-23	BOTTOM STRAP ATTACH BRACKET
	3		3		MS24694-S50		SCREW
	3		3		MS21042-3		NUT
	3		3		NAS1149F0363P		WASHER
	1		1		D4024-041	JCA/ASSO/MIN	ANCRA RESTRAINT STRAP
	1		1		D4004-041	JCA-M47-2-19	SIDE RESTRAINT ANGLE
	1		1		D4007-3	JCA-M47-2-18	TOP SUPPORT BRACKET
	1		1		D4006-041	JCA-M47-2-01	TANK TOP SUPPORT ASSEMBLY

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Revision: C

Date: 10.01.25

Qty -011	Qty -013	Qty -021	Qty -023	Qty -041	Part Number	Superseded Part Numbers	Description
	2		2		AN4-5A		BOLT
	2		2		NAS1149F0463P		WASHER
							Locker Preparation Parts
	1		1		D4005-041	JCA-M47-2-22	FORWARD FLOOR GUTTER
	1		1		D4063-1	193-6	DRAIN HOSE
	1		1		MS21919WDG-9		CLAMP
	1		1		MS35207-264		SCREW
	1		1		NAS1149D0332J		WASHER
	1		1		MS21042-3		NUT
	1		1		2000-6S		HOSE CLAMP
	3		3		NAS1474-08		SEALED CAPTIVE ANCHOR NUT
	1		1		D4005-11	JCA-M47-2-12	FINISHING STRIP
	4		4		MS21059-L08		ANCHOR NUT
	7		7		AN525-832R6		SCREW
							Electrical Parts
	1		1		D8-603		6.3A ECF FUSE (ALTERNATE HA23-6U3)
	1		1		D1-205		2.5A ECF FUSE (ALTERNATE HA21-2U5)
	1		1		MS35058-23		SWITCH
	1		1		107-964		CONNECTOR RECEPTACLE
	1		1		107-978		CONNECTOR BACKSHELL (ALTERNATE 105-5465)
	1		1		107-943		CONNECTOR PLUG
				1	D4025-1	VDO-M47-JCA	FUEL QUANTITY SENDER
	4		4		MS35206-217		SCREW
	4		4		NAS1149FN416P		WASHER
	4		4		MS21044N04		NUT
	1		1		143-207		PLUG
	1		1		143-208		RECEPTACLE
	1		1		143-204		RECEPTACLE HOUSING (ALTERNATE 973-1490)
	1		1		143-203		PLUG HOUSING (ALTERNATE 973-1482)
	5		5		143-219		CRIMP PIN (ALTERNATE 977-3800)
	5		5		143-217		CRIMP SOCKET (ALTERNATE 977-3797)
	1		1		D4009-041	JCA-M47-4-01	BONDING BRAID ASSEMBLY
	1		1		D4026-041	FL-100-R-JCA	FUEL GAUGE
	2		2		AN525-832R6		SCREW - GROUND STUD
	2		2		NAS1149FN832P		WASHER
	2		2		MS21042-08		NUT
	1		1		444-2556		GAUGE MASTER SWITCH
	1		1		D4022-5	3775628	THERMAL SWITCH (125°) - FARNELL (ALTERNATE 100-6847)
							General
	1		1		AN5800-1		PLACARD HOLDER
	1		1		AN929-6D		BLANK CAP
							Additional EC 130 Parts
			3		MS35207-264		SCREW
			3		NAS1149D0332J		WASHER
			3		MS21042-3		NUT
			1		D4027-041	JCA-M47-2-20	VENT CLAMP ASSEMBLY
			1		D4004-043	JCA-M47-2-04	SIDE RESTRAINT ANGLE AND TIE DOWN POINT

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Qty -011	Qty -013	Qty -021	Qty -023	Qty -041	Part Number	Superseded Part Numbers	Description
			1		D4005-5	JCA-M47-2-06	ANGLE
			4		D4005-7	JCA-M47-2-07	ANGLE
			1		D4005-9	JCA-M47-2-08	ANGLE
			1		D4007-1	JCA-M47-2-02	TOP SUPPORT BRACKET
			1		D4005-3	JCA-M47-2-05	FORWARD RESTRAINT BEAM
			2		AN4-6A		BOLT
			1		D4007-5	JCA-M47-2-24	PACKER
			60		MS20470AD4-4		RIVET
			30		MS20470AD4-6		RIVET
			10		CR3213-4-3		CHERRY MAX RIVET
			10		CR3213-4-2		CHERRY MAX RIVET
							Placards
	1				D3997-1	JCA-M47-P1	FUEL QUANTITY – AS 350 MODELS
			1		D3997-3	JCA-M47-P2	FUEL QUANTITY – EC 130 B4 MODEL
	1		1		D3997-5	JCA-M47-P3	AUX FUEL DRAIN
	1		1		D3997-7	JCA-M47-P4	AUX FUEL TRANSFER PUMP
	1		1		D3997-9	JCA-M47-P5	AUX FUEL
	1		1		D3997-11	JCA-M47-P6	WEIGHT AND BALANCE
	1		1		D3997-13	JCA-M47-P7	ON/OFF
	1		1		D3997-15	JCA-M47-P8	CHECK LOCKER TANK
	1		1		D3997-17	JCA-M47-P9	STOWAGE PROHIBITED
	1		1		D3997-19	JCA-M47-P10	TANK VENT
	1		1		D3997-21	JCA-M47-P13	SWITCH FIXED
	1		1		D3997-23	JCA-M47-P14	AUX FUEL
	1				D3997-25	JCA-M47-P15	CONVERSION CHART – AS 350 MODELS
			1		D3997-27	JCA-M47-P16	CONVERSION CHART – EC 130 B4 MODEL
	1		1		D3997-29	JCA-M47-P17	DO NOT OVERFILL WARNING
	1		1		D3997-31	JCA-M47-P18	ON/OFF
	1		1		D3997-33	JCA-M47-P19	AUX GAUGE FACE
	1		1		D3997-35	JCA-M47-P20	AUX FUEL GAUGE
	1		1		D3997-37	JCA-M47-P21	6.3 A CIRCUIT BREAKER
	1		1		D3997-39	JCA-M47-P22	2.5A CIRCUIT BREAKER
	1		1		D3997-41	JCA-M47-P23	AUX TANK NOT FITTED
	1		1		D3997-43	JCA-M47-P24	EARTH